

Tap M8 Z3

A10-020

The geminiTAP machine is equipped with 2 grinding spindles, 2 dressing units an oscillating table (W-axis) and a 6-axis robot. In the production cycle the dressing cycles are included. It is not needed to dress the flute wheel during every cycle, therefore we can reduce the cycle time by around 10 seconds.



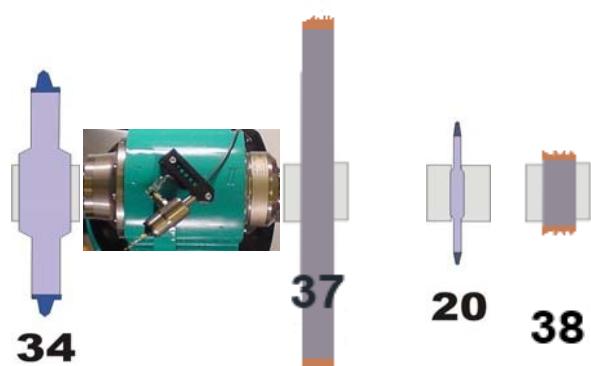
1. Cycletime for Production

Tool specifications							
	M8, Length 20 mm, flutelength 30 mm, Helix 0°						
Material HSS							
Operations							
Load		Flute	Thread rough	Thread fine	Chamfer	dress flute	dress thread
Feed [mm/Min]		2000	12000	12000	12000	100	100
Power [kW]		6	4	4	4	1	1
Cutting feed [m/s]		70	65	65	65	24	24
Used wheels							
Grinding time [s]	14	21	25	18	21	16	32
Total cycle time	2 Min 27						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø180 DXF A80
37 Ø400 1A1 A250
20 Ø125 14EE1 D301
38 Ø90 DXF D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : geminiTAP, dressing unit
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 14-16 bar
Software: Quinto 5

responsible engineer: FFR,16.01.14

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